

# Work Order ID 75325

October-20-11 2:56:02 PM

**\*75325\***

D 2724

Page 1

Item ID: D206-628-022

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step RH

Start Date: 20/10/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: H.C.J

Date: 11/10/20

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-022 CHG 003

*8/11/14*

*H.C.J. M.L.J. 11-11-11*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*u.l.u. S (4)*

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*8/11/14*

*x4  
12/1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 75325****\*75325\***

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Item ID: D206-628-022

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step RH

Start Date: 20/10/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				11/11/11	1	(4)	
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-022								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

11/11/15  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 75325

**\*75325\***

Parent Item: D206-628-022

**\*D206-628-022\***

Parent Item Name: Heli-Access-Step RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev:D as per ECN 766 JLM  
 IPP Rev:E as per ecn 1118 DD verified by:EC  
 10.08.13 CHG QTY OF RUBBER DD verf by:EC  
 IPP Rev:F

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD416	NAS1149D0463J	Purchased		No			Each	0.0000	12	48			
------------	---------------	-----------	--	----	--	--	------	--------	----	----	--	--	--

**\*AN960JD416\***

Washer

D2724-042		Manufactured		No			Each	0.0000	1	4			
-----------	--	--------------	--	----	--	--	------	--------	---	---	--	--	--

**\*D2724-042\***

206L Step Assembly

AN4-14A		Purchased		No		120	Each	263.0000	4	16			
---------	--	-----------	--	----	--	-----	------	----------	---	----	--	--	--

**\*AN4-14A\***

Bolt

### Location

### Loc Qty

### Loc Code

ST357

263

118628

100

118706

63

119127

100

		Purchased		No		120	Each	567.0000	8	32			
--	--	-----------	--	----	--	-----	------	----------	---	----	--	--	--

AN4-15A

**\*AN4-15A\***

Bolt

### Location

### Loc Qty

### Loc Code

ST358

567

118112

4

118648

263

118706

200

119127

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**\*75325\***

Parent Item: D206-628-022

**\*D206-628-022\***

Parent Item Name: Heli-Access-Step RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2731-7

Manufactured No

120

Each

48.0000

4 16

\*\*

**\*D2731-7\***

Mounting Lug

Location

Loc Qty

Loc Code

ST468A

48

71860

48

D2732-030

Manufactured No

120

Each

4.0000

8 32

\*\*

**\*D2732-030\***

Rubber Cushion

Location

Loc Qty

Loc Code

ST409

4

56515

0

64283

4

D3394-043

Manufactured No

120

Each

21.0000

4 16

\*\*

**\*D3394-043\***

Lug Assembly

Location

Loc Qty

Loc Code

ST475

21

62930

1

66429

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Parent Item: D206-628-022

**\*D206-628-022\***

Parent Item Name: Heli-Access-Step RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

120

Each

13,966.00

12

48

\*\*

11/11/11

sl 4

**\*MS21042I 4\***

Nut

Location

Loc Qty

Loc Code

ST300

2966

117441

51

117601

537

118451

1378

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

### 5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE



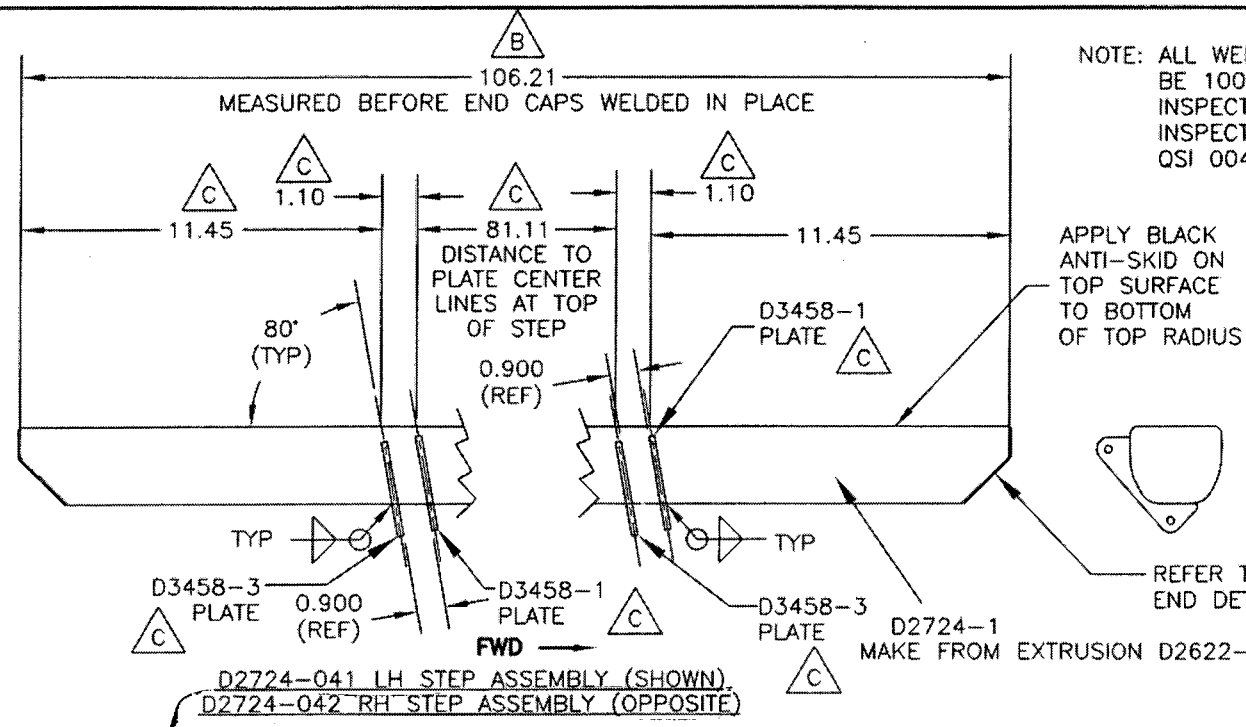


RELEASED  
05.11.14

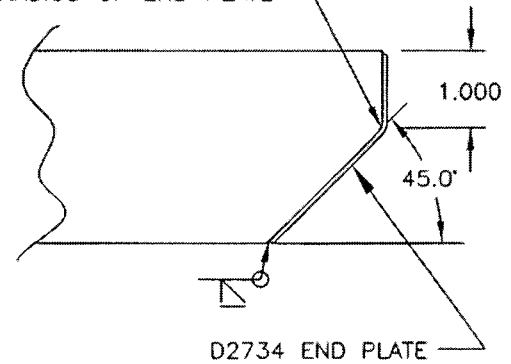
REFERENCE ONLY

DESIGN	DRAWN BY	DATE	TITLE	REV. C
KE	PH	05.09.19	206L/407 STEP ASSEMBLY	NTS
CHECKED	APPROVED		DRAWING NO. D2724	SHEET 1 OF 1
A		97.12.04	NEW ISSUE	
B		98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C		05.09.19	RE-DESIGN, ADD D3458-1/-3	

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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